

Work Order ID 53832-1

November 19, 2009 11:37:53 AM

ASAP

Split



Item ID: D4011-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp, Short

Start Date: 11/19/09

Start Qty: 10



Cust Item ID:

Required Date: 11/24/09

Req'd Qty: 80.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4011

B

101

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

cut per drwg D4011
Rev. B Prog Rev: B
Deburr is necessary

HB 9-11-21

102

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-11-21

103

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) S or 11/23

counte

(170) /

(120)

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Page 2

Item ID: D4011-1

Revision ID:

Item Name: Clamp, Short

Start Date: 11/19/09 Start Qty: 80.00

Required Date: 11/24/09 Req'd Qty: 80.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

104



Small Fab

Small Fab

Memo

Form as per drwg
D4011 Rev.B

0.00

0.00

80 09/11/24 < 16

105



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

→ 09/11/24

(16) +

130



Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

0.00

109/11/24 (16)

Work Order ID 53832

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Page 3

Item ID: D4011-1

Revision ID:

Item Name: Clamp, Short

Start Date: 11/19/09 Start Qty: 80.00

Required Date: 11/24/09 Req'd Qty: 80.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/11/24

MF
09-11-24

eklist Print

November 20, 2009 8:38:02 AM

Page 1

Work Order ID: 53832

Parent Item: D4011-1

Parent Item Name: Clamp, Short

Comments: IPP RevA: New issue 09.10.26 DD verified by:JLM
dwg chg Prelim-B 09.11.12 DD verified by:EC
dwg 09.11.18 DD verified by:JLM

IPP RevB:
IPP RevC: revC as per

Start Date: 11/19/09

Start Qty: 80.00

Required Date: 11/24/09

Required Qty: 80.00

Component Item ID/
M304S14GA

Replacement

Mfg/
Purchased

Bin
No

Primary

Last

Route

Unit of
sf

Qty on
25.9521

Remaining
4.8000

Qty
7.2

Date

Status



304SS sheet .080



B 9-11-21

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

25.9521

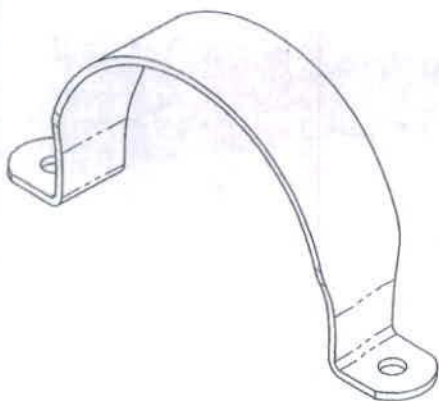
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25.9521

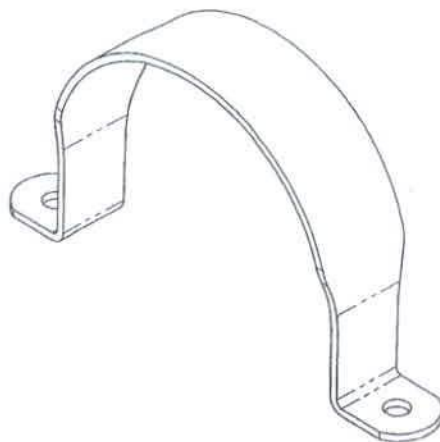
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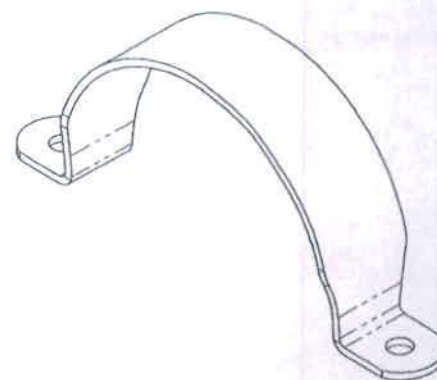
W0 53832



D4011-1 CLAMP, SHORT



D4011-3 CLAMP, LONG



D4011-5 CLAMP, SHORT (OEM)

NOTES

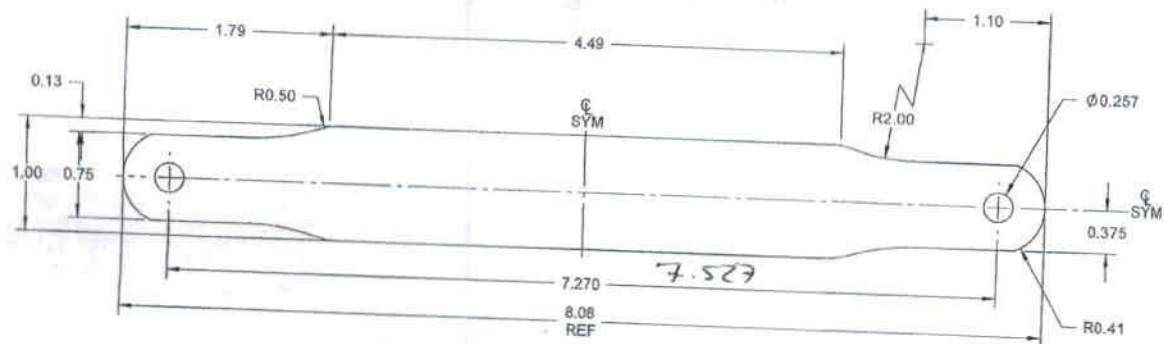
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PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

B	SHORTEN HEIGHT OF 1/3 CLAMPS BY 0.125, ADDED -S, REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKID TUBES	MB	09.11.11
A	NEW ISSUE	MB	05.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.11		

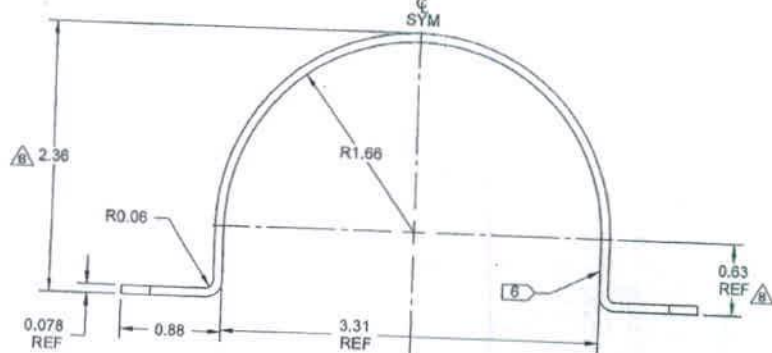
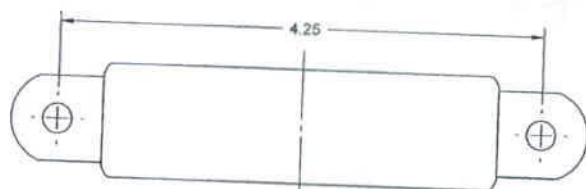
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4011** REV. B
SHEET 1 OF 4
TITLE **CLAMP** SCALE
NTS

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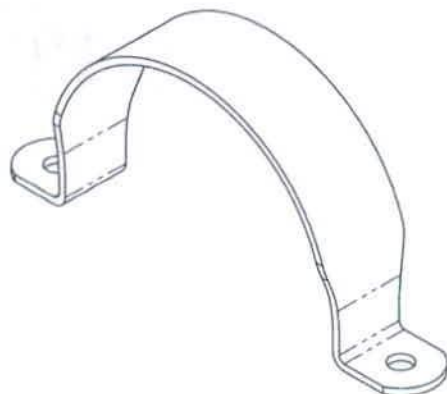


D4011-1F CLAMP, SHORT FLAT PATTERN

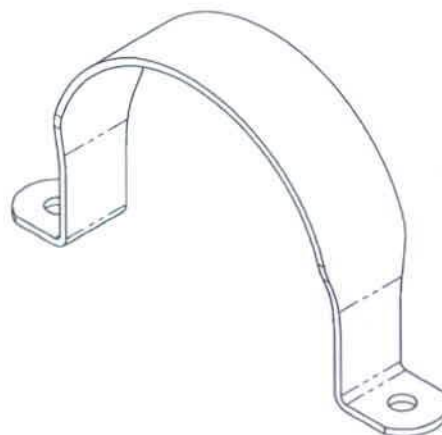


**D4011-1 CLAMP, SHORT
(MAKE FROM D4011-1F)**

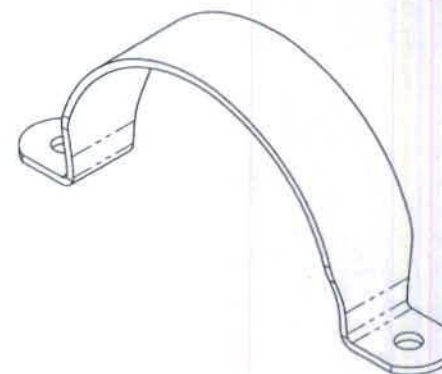
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4011	SHEET 2 OF 4
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D4011-1 CLAMP, SHORT



D4011-3 CLAMP, LONG



D4011-5 CLAMP, SHORT (OEM)

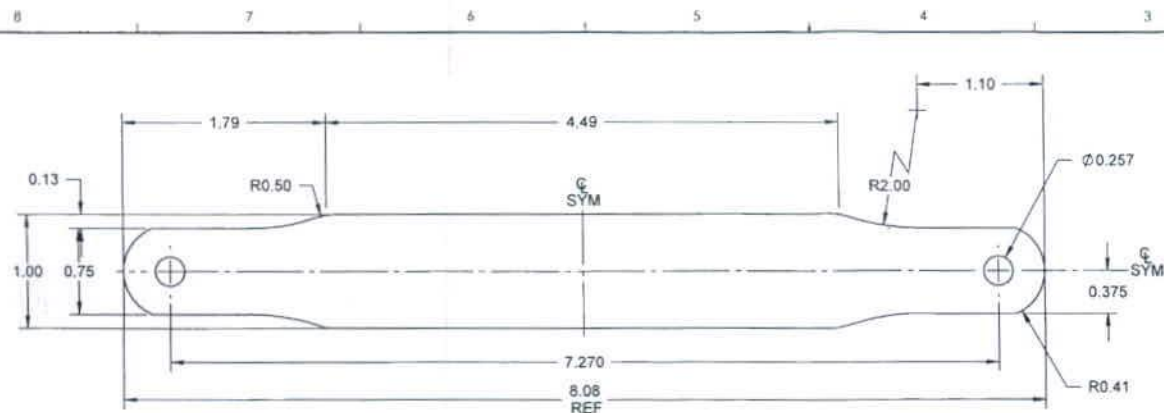
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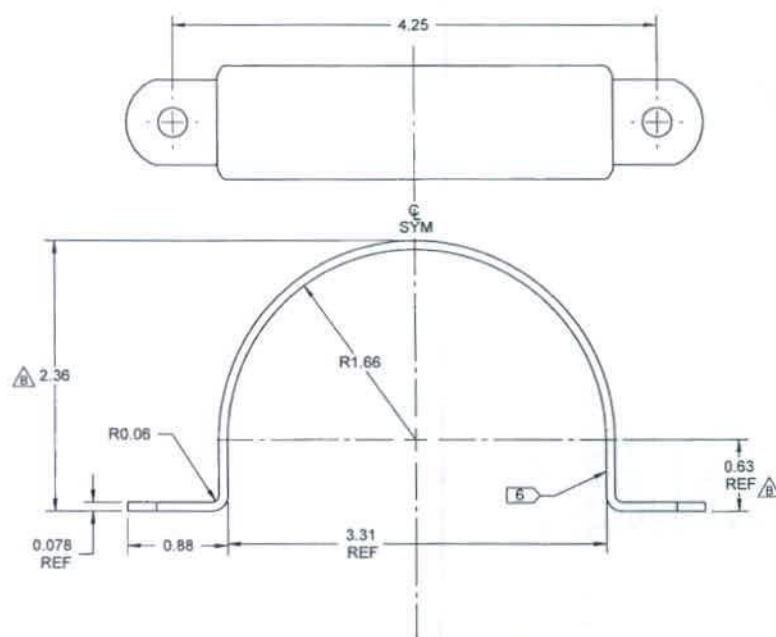
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

B	SHORTEN HEIGHT OF -1A-3 CLAMPS BY 0.125; ADDED -5. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKIDTUBES	MB	09.11.11
A	NEW ISSUE	MB	09.10.21
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	AS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.11		
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D4011-1F CLAMP, SHORT FLAT PATTERN

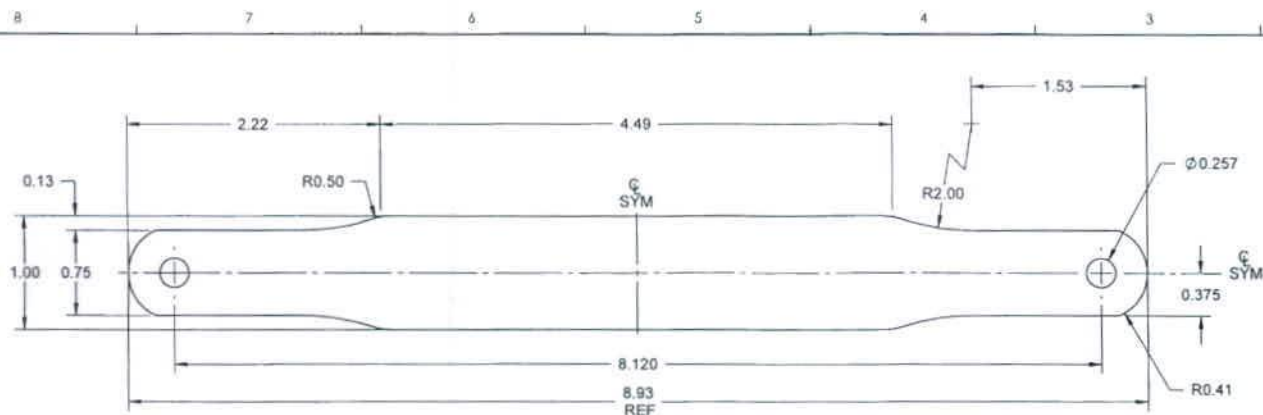


**D4011-1 CLAMP, SHORT
(MAKE FROM D4011-1F)**

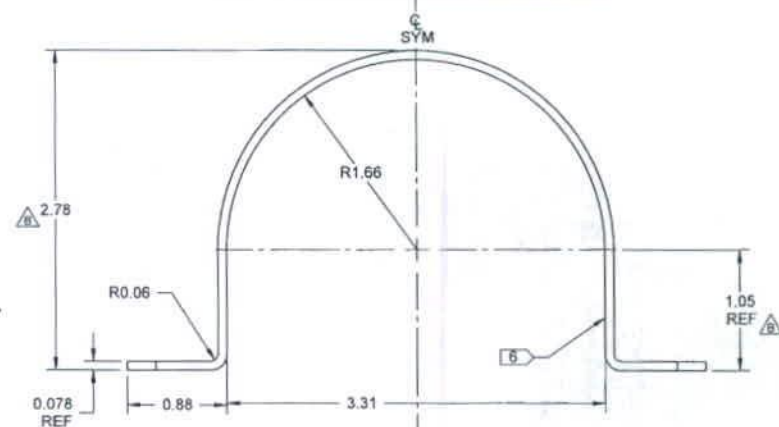
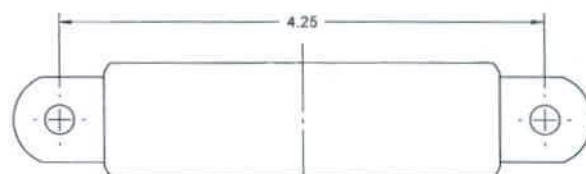
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D4011-3F CLAMP FLAT PATTERN, LONG

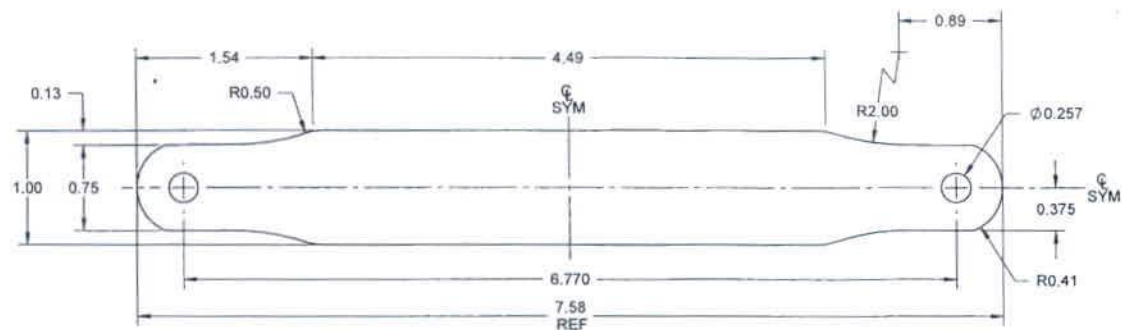


D4011-3 CLAMP, LONG
(MAKE FROM D4011-3F)

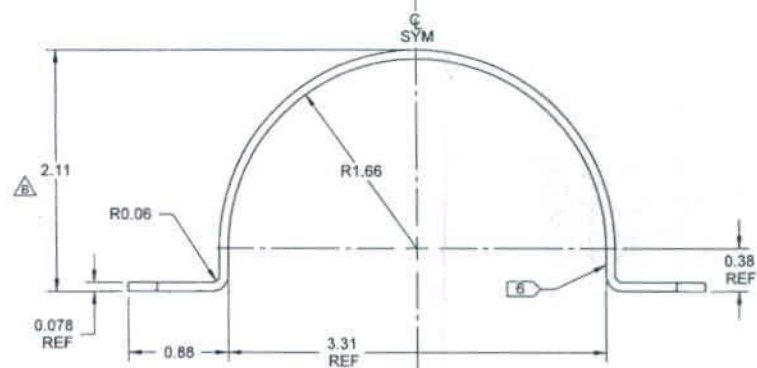
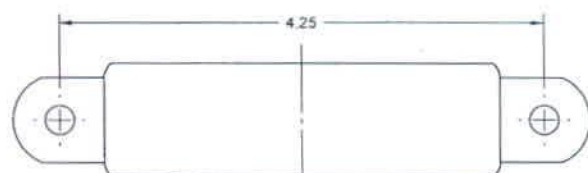
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D4011-5F CLAMP, SHORT (OEM) FLAT PATTERN



D4011-5 CLAMP, SHORT (OEM)
(MAKE FROM D4011-5F)

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CHECKED	ASS	DRAWING NO.	REV. B
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